

Work Order ID **92121*****92121***

Page 1

Tuesday, October 23, 2012 4:12:04 PM

Item ID: PB67-43001-09

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLSDate: 12-10-25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-09

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001** ensure
no burn thru after welding in tube -235 and -229 only where bushing -265 ***

2

0

12.12.04

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

DAS
09
9-89

12-12-04

②

2

0

12.11.07

DAS
10
9-89P70
12.12.04

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
09
9-89DAS
09
9-89

12-12-04

②

NCR: ☒ Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA ☒ Date: 12/12/21QA Closed: ☒ Date: 11

Work Order: <u>92121</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>PB67-43001-09</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>12-2143</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	12/12/04	100	X1	Found at inspection that PB67-43001-311 is weld @ 30.250" with a spacing of 1.125". should be @ 30.3125" and have a spacing @ of 30.60" RC not welded at correct location no locator on weldy sig.	12/12/4	Cut all top PB67-43001-311 and see re locate in correct location. Grains weldy flush. and re weld as per 057 cut A/R <u>122358</u>	12-12-04	DAS 09 2-83 12-12-04	DAS 16 2-83 12/12/04
Equip/Tooling <input checked="" type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
		<input checked="" type="checkbox"/> Other Should have a locator on jig for location and distance from weldy parts.

Work Order ID 92121

Tuesday, October 23, 2012 4:12:04 PM

92121

Page 2

Item ID: PB67-43001-09 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Blade Fold Assembly Weldment
Start Date: 10/23/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 11/2/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130	Powdercoat	0.00				2X	✓		mt 12/12/10
	Powder Coating								
	Memo								
	in detail D, mask in between -311 prior to paint**mask 1.750" on the end of -243 prior to paint*****mask inside of D3440-9 prior to paint***START TIME: 11:40 FINISH TIME: 12:10 OVEN TEMPERATURE: 320°F								
140	QC3- Inspect Part Finish	0.00							
140	QC	0.00				2	✓	12-12-10	258
	Quality Control								
	Memo								
150	Identify as per dwg & Stock Location: MM003	0.00							
150	Packaging	0.00				2	✓		12.12.12
	Packaging								

Work Order ID 92121***92121***

Page 3

Tuesday, October 23, 2012 4:12:04 PM

Item ID: PB67-43001-09

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/12/13

MF
12-12-12

Picklist Print

Tuesday, October 23, 2012 4:12:04 PM

Page 1

Work Order ID: 92121

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec
dwg EC verified by:DD

IPP RevB 10.09.24 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-201 Square Tube		Manufactured	No		B92212 = 4	100	Each	0.0000	2	4		12.12.03	
PB67-43001-203 Square Tube		Manufactured	No			100	Each	4.0000	1	2		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST437		4							
				62105		4							
PB67-43001-209 Square Tube		Manufactured	No		B90918 = 2	100	Each	0.0000	1	2		12.12.03	
PB67-43001-210 Square Tube		Manufactured	No			100	Each	2.0000	6	12		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA	B90919 = 10	2							
				85179		2							
PB67-43001-213 Flanged Hook		Manufactured	No			100	Each	1.0000	2	4		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438	B92216 = 4	1							
				52488		1							
PB67-43001-229 Outer Tube		Manufactured	No			100	Each	1.0000	1	2		12.12.03	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST209a	B90921 = 2	1							
				52487		1							
PB67-43001-235 Outer Tube		Manufactured	No		B90923 = 2	100	Each	0.0000	1	2		12.12.03	

Picklist Print

Tuesday, October 23, 2012 4:12:04 PM

Page 2

Work Order ID: 92121

Parent Item: PB67-43001-09

Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-239
Square Tube

Manufactured No

100 Each 1.0000

1 2

12.11.07

Location Loc Qty Loc Code
ST443 *B90924 = 2*
44986 1

2

PB67-43001-243
Tube Handle Extension

Manufactured No

100 Each 0.0000

1 2

12.12.03

PB67-43001-277
Contoured Male Eye

Manufactured No

100 Each 3.0000

1 2

12.12.03

Location Loc Qty Loc Code
ST438 *92217 = 1*
62110 3

1

PB67-43001-311
Restraint

Manufactured No

100 Each 2.0000

2 4

12.12.03

Location Loc Qty Loc Code
ST439 *B90935 = 4*
62112 2

4

D3440-9
Tube Detent Clip Base (Supersedes B67-43001-241)

Manufactured No

100 Each 2.0000

1 2

12.12.03

Location Loc Qty Loc Code
WA *B92218 = 2*
85178 2

D3440-13
Bracket (Supersedes B67-43001-273)

Manufactured No

100 Each 0.0000

1 2

12.12.03

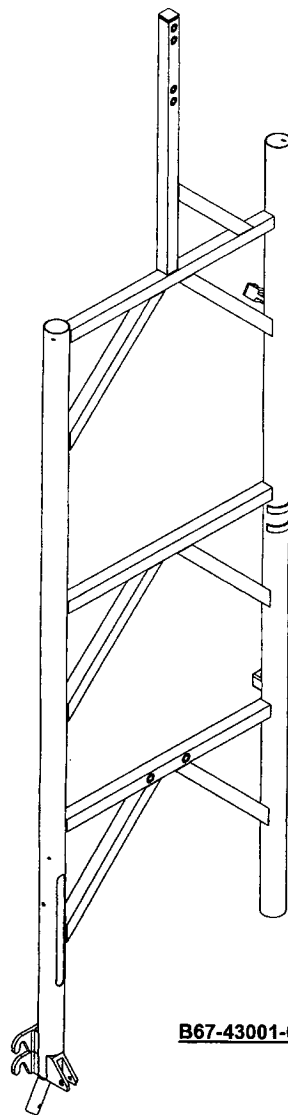
~~PB67-43001-223 qty = 14~~
~~PB67-43001-225 qty = 4~~
~~PB67-43001-227 qty = 2~~

Batch *47504 = 2* *12.12.03*
Batch *44988 = 8* *12.12.03*
Batch *N/A*

Tuesday, October 23, 2012 4:12:04 PM

Shop Packet Print

Page 2



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

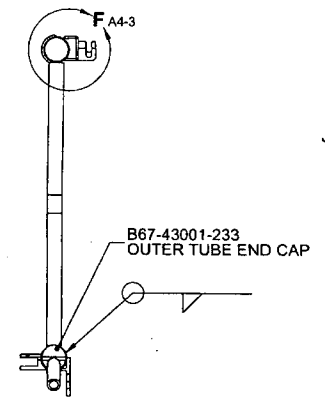
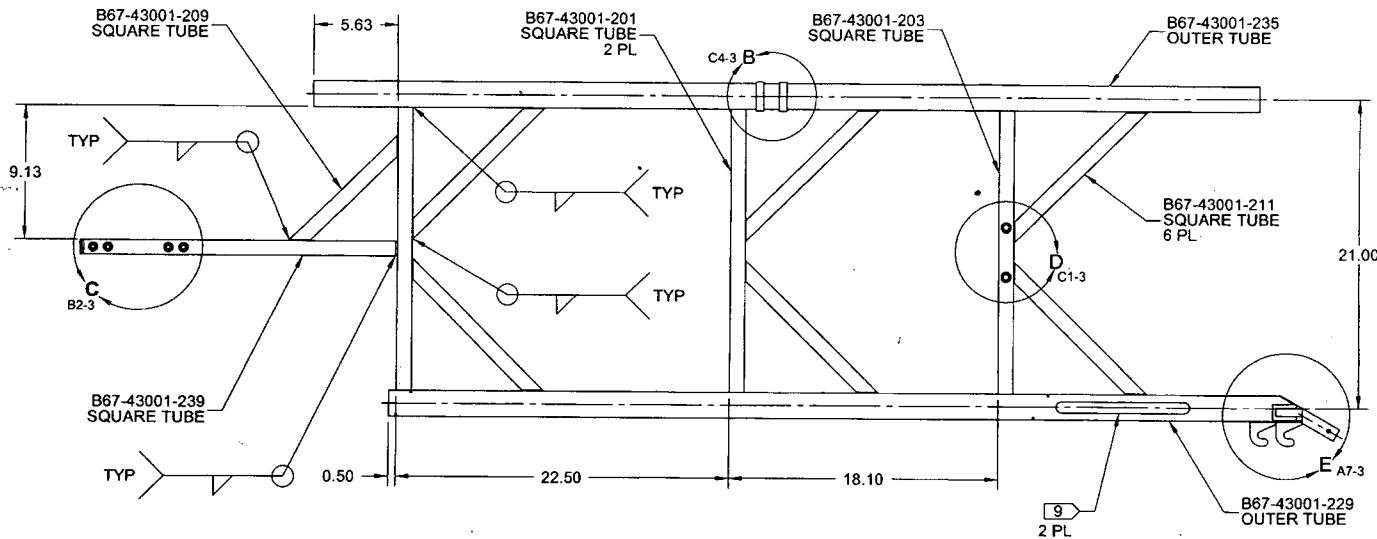
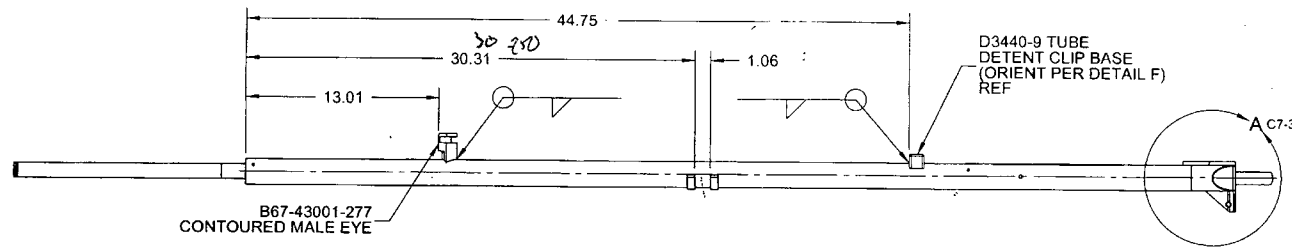
SHOP COPY
R. J. W. CO.
ENGINEERS
UNION
ST. LOUIS
MO.
92121 MLS
12-10-25

ITEM	QTY -09	P/N	DESCRIPTION
1	X	B67-43001-09	AFT BLADE FOLD ASSEMBLY WELDMENT
2	2	B67-43001-201	SQUARE TUBE
3	1	B67-43001-203	SQUARE TUBE
4	1	B67-43001-209	SQUARE TUBE
5	6	B67-43001-211	SQUARE TUBE
6	2	B67-43001-213	FLANGED HOOK
7	1	B67-43001-223	SQUARE CAP
8	4	B67-43001-225	BUSHING
9	2	B67-43001-227	BUSHING
10	1	B67-43001-229	OUTER TUBE
11	1	B67-43001-233	OUTER TUBE END CAP
12	1	B67-43001-235	OUTER TUBE
13	1	B67-43001-239	SQUARE TUBE
14	1	B67-43001-243	TUBE HANDLE EXTENSION
15	1	B67-43001-277	CONTOURED MALE EYE
16	2	B67-43001-311	RESTRAINT
17	1	D3440-9	TUBE DETENT CLIP BASE
18	1	D3440-13	BRACKET

RELEASED
R 2010-09-16
ND

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 6 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.05.03
REV.		DESCRIPTION	BY	DATE	
DESIGN	R/W	DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		B67-43001-09	SHEET 1 OF 3		
APPROVED		TITLE	SCALE		
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS		
DATE	10.05.03	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

92121



B67-43001-09 AFT BLADE FOLD ASSY WELDMENT

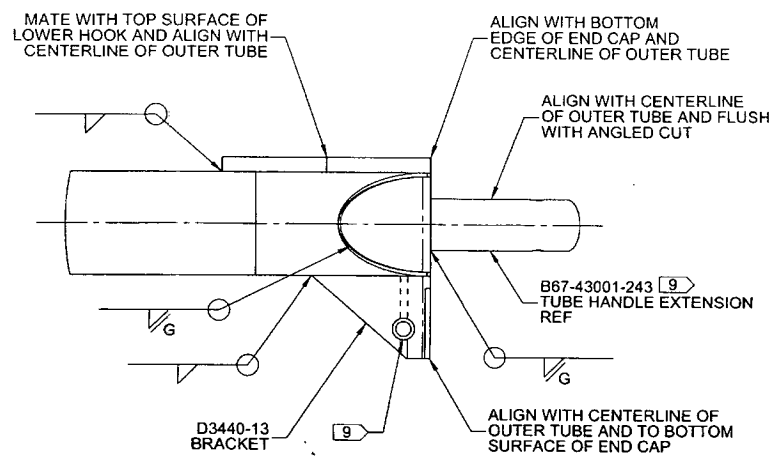
RELEASED
2010-09-16

NOTES:

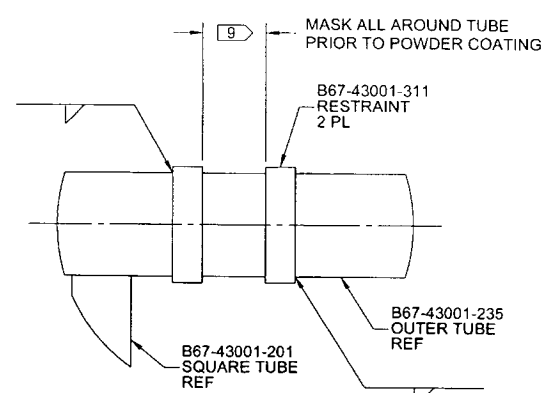
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.74 lbs
- 8) WELDING: PER QSI 004
- 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-09	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY WELDMENT	NTS
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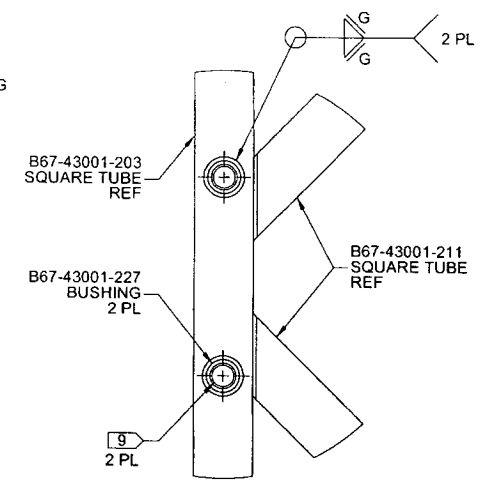
92121



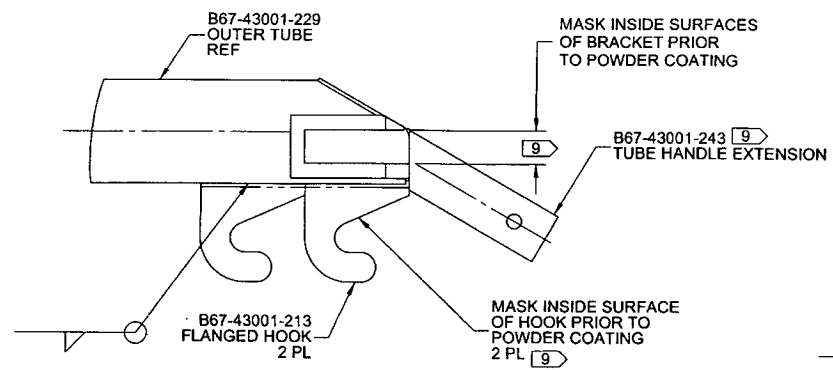
DETAIL A D3-2
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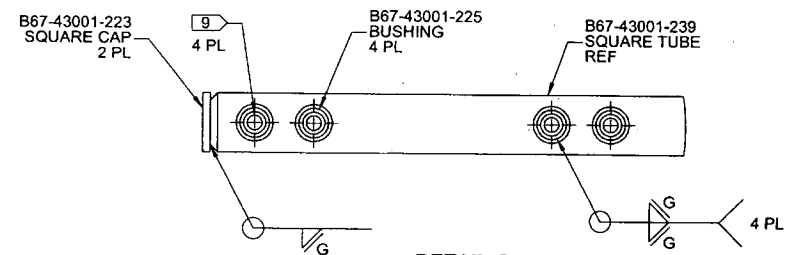
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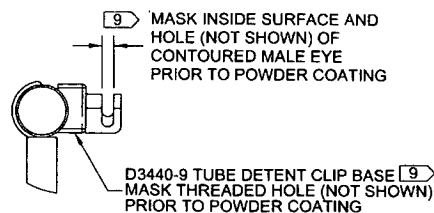
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SCALE 4X



DETAIL E B3-2
SCALE 4X



DETAIL C B8-2
SCALE 4X



DETAIL F C2-2
SCALE 4X

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. B67-43001-09	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		AFT BLADE FOLD ASSY WELDMENT	
DE APPR.	N/A	NTS	
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